

Date: Thursday, 12/13/2007 2:38:58 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 36325		Part Number	: D2574		
Estimate Number	: 10534		Drawing Number	: D2574 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/13/2007	S.O. No. : N/A	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/10/2008		
Previous Run	: 35934		Qty:	16	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev J As Per Rev E 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B 31388</u> SF 08/01/08</p>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 PTO
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>36325</u> Double check by: <u>J.L.</u></p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Déburr and remove all machining marks 5-Tumble to remove sharp edges.</p> <p style="text-align: right;"><u>SF 08/01/08</u></p>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<p>Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 SF 08/01/08</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE SF 08/01/08</p>		

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng.	Sign & Date			
08/01/09 # 20		During second operator machines shortened the 1 st rough the holder hit the part and caused a large chamber R.C. Hammon error	CP 08.01.09 pw QS1042	Build out chamber & blend in. PART ACCEPTABLE. DOES NOT AFFECT STRENGTH OF PART	S-F 08/01/09	(08/01/09	CP 08.01.09 pw QS1042	(08/01/09

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 36325

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 08/01/17

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



16X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-f

08/01/15

7.0 POWDER COATING POWDER COATING



16X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f

08/01/16

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS

FL

08/01/16

(16)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST433

AS

08/01/17

(16)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

D

08/01/17

Job Completion



u 08.01.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	36325
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

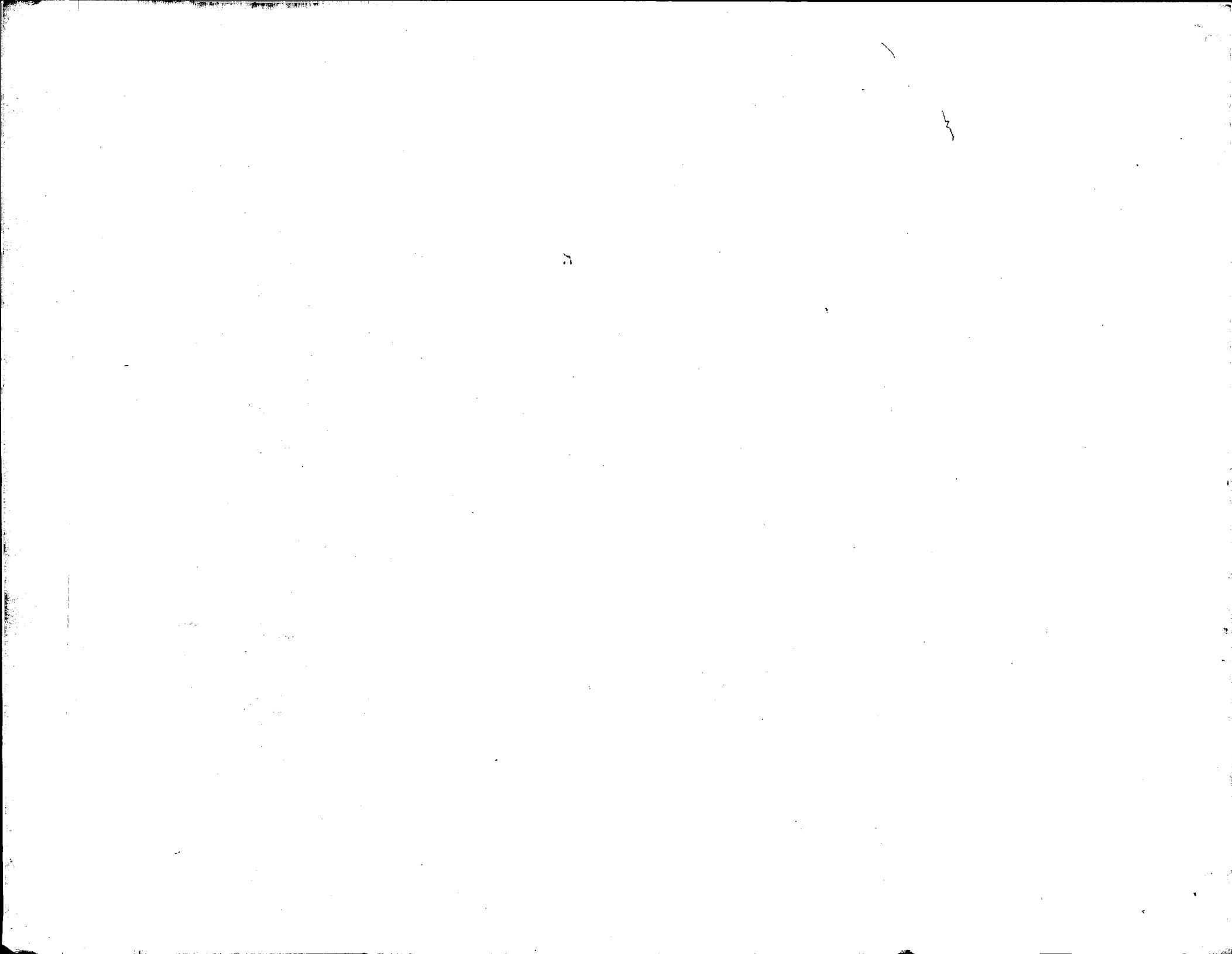
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.375	1.375	1.375	1.375		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.240	.256	.256	.256		
S	0.115	0.135		.126	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.230	.238	.230	.230		
W	0.115	0.135		.135	.128	.128	.128		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.358	.360	.360	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.520	1.517	1.510	1.510		
AF	0.115	0.135		.125	.130	.130	.130		
AG	0.240	0.280		.285	.275	.275	.275		
AH	0.240	0.260		.250	.251	.250	.252		
AI	2.000	2.020		2.000	2.002	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: 8F
Date: 08/01/08

Audited by: SA
Date: 08/01/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>SA</u>



DART AEROSPACE LTD				Work Order:	36325
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

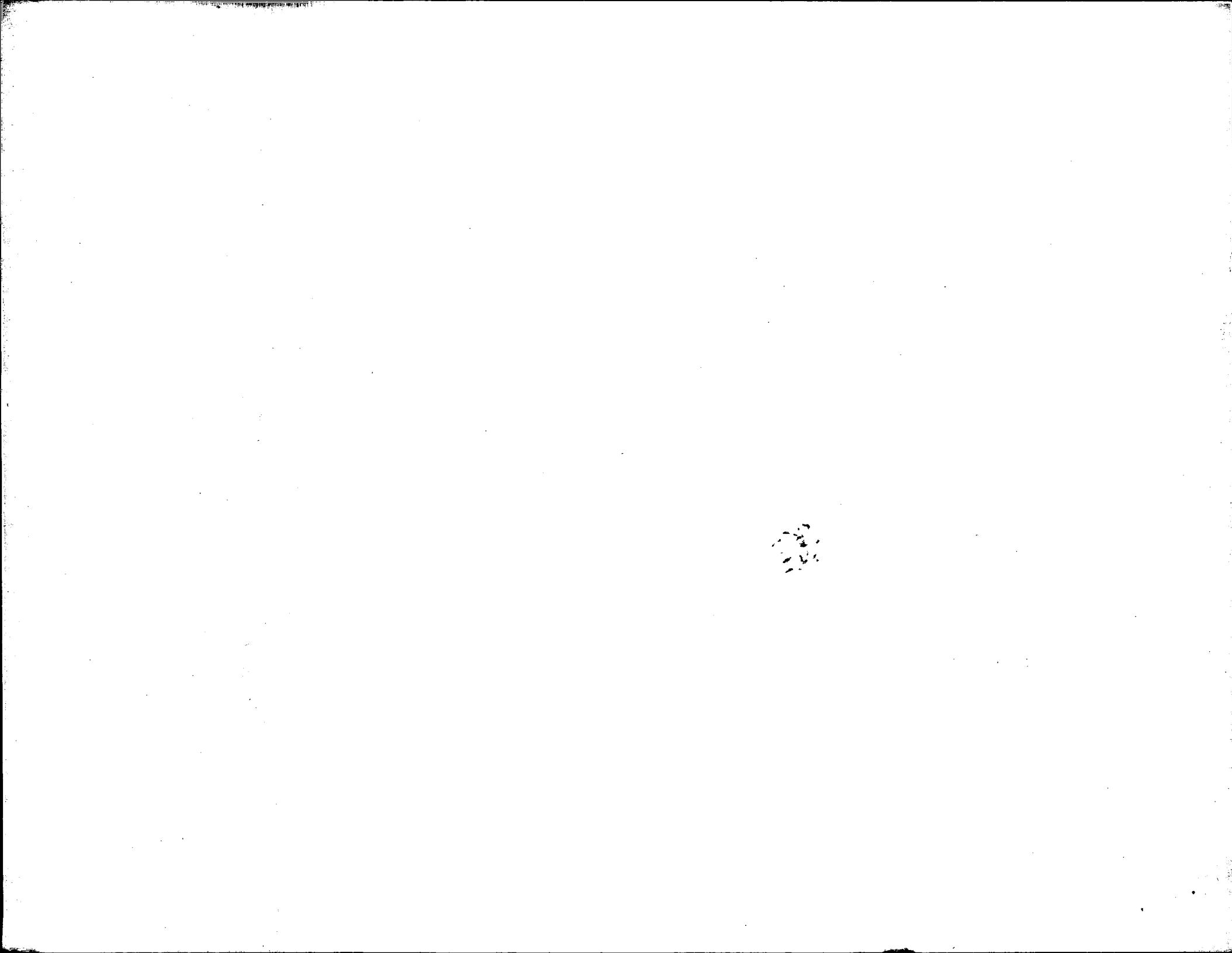
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				50	68	73	84		
A	0.438	0.443		.4400	.4400	.4400	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.505	.505	.505	.505		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.376		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.567	.567	.569	.569		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.375	1.375	1.375	1.375		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.128	.128	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.134	.134	.134	.134		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.635	.635	.6		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.002	2.002	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: 8-5 156
Date: 08/01/09

Audited by: SD
Date: 08/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>SD</u>



DART AEROSPACE LTD				Work Order:	36325
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

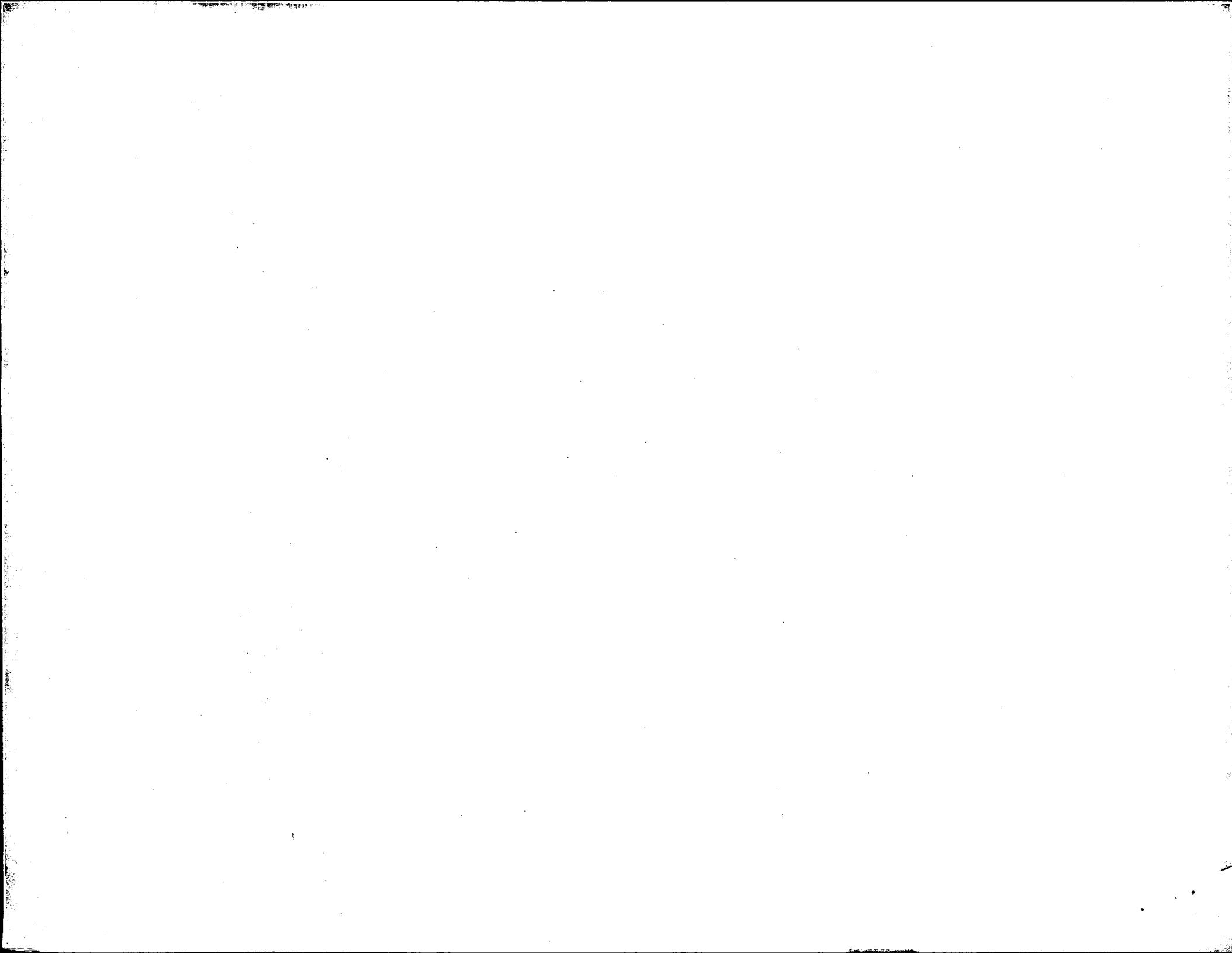
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.505	.500	.507	.502		
G	0.257	0.262		.260	.258	.258	.258		
H	0.375	0.380		.376	.377	.377	.377		
I	0.490	0.510		.502	.500	.500	.500		
J	1.174	1.184		1.179	1.180	1.180	1.180		
K	0.558	0.578		.569	.568	.568	.568		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.124	4.124	4.124		
P	0.115	0.135		.125	.128	.130	.130		
Q	0.115	0.135		.130	.135	.135	.135		
R	0.240	0.260		.255	.255	.255	.255		
S	0.115	0.135		.130	.126	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		.241	.243	.243	.243		
W	0.115	0.135		.132	.135	.130	.130		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.764	.764	.760	.760		
Z	0.352	0.372		.362	.362	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.515	1.515	1.515	1.515		
AF	0.115	0.135		.135	.135	.130	.130		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.005	2.002	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: *RG/8F*
Date: *08/01/12*

Audited by: *SD*
Date: *08/01/14*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>RF</i>	<i>JLM</i>



DART AEROSPACE LTD				Work Order:	36325
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13 1	142	15 3	164		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.500	.501	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.376	.376		
I	0.490	0.510		.503	.502	.502	.502		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.123	4.124		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.258	.258	.256	.257		
S	0.115	0.135		.126	.128	.128	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		.242	.240	.240	.240		
W	0.115	0.135		.125	.128	.128	.128		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.628	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.251	.251		
AI	2.000	2.020		2.001	2.001	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 85
Date: 08/01/12

Audited by: JK
Date: 08/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>JK</u> <u>JLM</u>

